



Dart Aerospace Ltd.
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D3913-041
Job Sheet 189953



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	2/15/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	2/15/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		DAS
							QC 9 - 24		24
							QC 9 - 43		9-89
							QC 9 - 50		
120	QC 5	1 pcs	2/15/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		DAS
							QC 5 - 24		24
							QC 5 - 3		9-89
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	2/15/19	0.00	0.29	Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	D.B 19/2/19
						Handfinish - 2 - 3 - B4B	
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	2/15/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	BEB 19-02-19
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
135	Packaging 1-1 - Pick Kit - B4B	1 pcs	2/15/19	0.00	0.00	Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	BEB 19-02-20
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
140	QC 3	1 pcs	2/15/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 19-2-20
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 26	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	

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DAS
15
9-89

						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 38	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 6	
						QC 3 - 68	
						QC 3 - 9	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	2/15/19	0.00	0.50	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BEB19-02-20
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
160	QC 5	1 pcs	2/15/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 38	
						QC 5 - 42	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
170	Packaging 3-1 - Stock - B4B	1 pcs	2/15/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	DAS
				Packaging 3 - 34 - B4B	21
				Packaging 3 - 35 - B4B	9-09 FEB 20 2019
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	2/15/19	0.00 0.00	QC 21 - SA - 21	DAS FEB 20 2019
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	9-09
Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 110 - QC9- Inspect visual per QSI004- Fusion Welds 120 - QC5- Inspect part completeness to step on W/O 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat <i>M138997 START: 1.45 TEMP: 375° FINISH: 2.15</i> 135 - Pick Kit 140 - QC3- Inspect Part Finish 150 - Assemble as per dwg - Pick Kit 160 - QC5- Inspect part completeness to step on W/O 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S143 339
D3913-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S148 464
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S143 390
D3913-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S145 057
D3913-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S143 685
D3913-9 ✓	Hinge Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S148 608
D3916-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	100-Large Fab - Basket - 1	S149 947
D3916-5 ✓	Light Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	S151 590
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	S115 309
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	S143 935
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S148 935
D4020-11 ✓	End Mesh, Basket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S149 407
D4021-1 ✓	Handle Plate	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	S143 400
D4034-041 ✓	Aft Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S143 301
D4034-043 ✓	Fwd Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S152 401
D4672-1 ✓	Blanking Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S145 300
M304EX0.75-16F ✓	Expanded Metal Flat SS	33 sf (33 ea) ✓	100-Large Fab - Basket - 1	S125 258
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S132304-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S076007
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S094592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S134693-1
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S144379
NAS1149FN832P	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S136368-1

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	75	0
	D3913-1	1	5	0
	D3913-15	1	17	0
	D3913-3	1	5	0
	D3913-7	2	12	0
	D3913-9	1	10	0
	D3916-041	2	8	0
	D3916-5	3	12	0
	D4016-1	3	144	0
	D4017-7	3	31	0
	D4017-9	2	22	0
	D4020-11	2	30	0
	D4021-1	3	56	0
	D4034-041	1	4	0
	D4034-043	1	3	0
	D4672-1	2	36	0
	M304EX0.75-16F	33	2,047	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	235	0
	D2931	2	815	0
	D4021-5	2	38	0
	MS20600-AD4W3	2	147	0
	MS21042L3	6	2,782	0
	NAS1149F0332P	12	3,048	0
	NAS1149FN832P	2	3,162	0

Part Specifications

Specifications could not be found.

Plex 2/5/19 10:27 AM Dart.Hadley.Shannon



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D3913-041
Job Sheet 189953



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		2/15/19	0.00	10.00	Large Fab 1		
110	QC	1 pcs		2/15/19	0.00	0.00	QC9		
120	QC	1 pcs		2/15/19	0.00	0.00	QC5		
125	HandFinish	1 pcs		2/15/19	0.00	0.29	HandFinish2		
130	Powdercoat	1 pcs		2/15/19	0.00	0.93	Powdercoat2		
135	Packaging	1 pcs		2/15/19	0.00	0.00	Packaging1		
140	QC	1 pcs		2/15/19	0.00	0.00	QC3		
150	HandFinish	1 pcs		2/15/19	0.00	0.50	HandFinish4		
160	QC	1 pcs		2/15/19	0.00	0.00	QC5		
170	Packaging	1 pcs		2/15/19	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea		2/15/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	
D3913-1	Rib	1 pcs (1 ea)	90-Start up Operation	
D3913-15	Wide Handle Plate	1 pcs (1 ea)	90-Start up Operation	
D3913-3	Rib	1 pcs (1 ea)	90-Start up Operation	
D3913-7	Rib	2 pcs (2 ea)	90-Start up Operation	
D3913-9	Hinge Rib	1 pcs (1 ea)	90-Start up Operation	
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	
D3916-5	Light Rib	3 pcs (3 ea)	90-Start up Operation	
D4016-1	Hinge Half, Base	3 pcs (3 ea)	90-Start up Operation	
D4017-7	Rib	3 pcs (3 ea)	90-Start up Operation	
D4017-9	Rib	2 pcs (2 ea)	90-Start up Operation	
D4020-11	End Mesh, Basket	2 pcs (2 ea)	90-Start up Operation	
D4021-1	Handle Plate	3 pcs (3 ea)	90-Start up Operation	
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	90-Start up Operation	
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	90-Start up Operation	
D4672-1	Blanking Plate	2 pcs (2 ea)	90-Start up Operation	
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	
D2931	Bumper	2 pcs (2 ea)	150-HandFinish	
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	
D4021-5	Blanking Plate	2 pcs (2 ea)	150-HandFinish	
NAS1149FN832P	Washer	2 Ea (2 ea)	150-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	79	0
	D3913-1	1	6	0
	D3913-15	1	18	0
	D3913-3	1	6	0
	D3913-7	2	10	0
	D3913-9	1	11	0
	D3916-041	2	10	0
	D3916-5	3	18	0
	D4016-1	3	147	0
	D4017-7	3	34	0
	D4017-9	2	12	0
	D4020-11	2	23	0
	D4021-1	3	59	0
	D4034-041	1	5	0
	D4034-043	1	4	0
	D4672-1	2	16	0
	M304EX0.75-16F	33	2,104	0
150-HandFinish	AN3-10A	6	235	0
	D2931	2	815	0
	D4021-5	2	20	0
	MS20600-AD4W3	2	147	0
	MS21042L3	6	2,814	0
	NAS1149F0332P	12	1,641	0
	NAS1149FN832P	2	3,162	0

Part Specifications

Specifications could not be found.

Plex 2/1/19 9:31 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S153543



Part: D3913-041

Job No: 189953

Serial No/Batch: S153543

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/14/19